

# Work Order ID 70038

Wednesday, May 25, 2011 1:03:31 PM



Page 1

Item ID: D3372-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Main Body					
Start Date: 5/25/2011	Start Qty: 4.00				
Required Date: 6/10/2011	Req'd Qty: 4.00				
Reference:					
Approvals: Process Plan: <u>CZ</u>	Date: <u>11/04/25</u>	Tooling:		Date:	
QC:	Date:	SPC (Y/N):		Date:	
			Run	Start	
				Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3372	Rev B								

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 1.500" x 3.000" x 4.450" long								
110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine D3372-1 as per Folio FA496 and Dwg D3372								
	Identify as D3372-1								
	Deburr								
120		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

*Handwritten: 11/07/07*

*Handwritten: B.A. 11/07/14*

*Handwritten: B.A. 11/07/14*

*Handwritten: 4 0*

*Handwritten: 4 0*

*Handwritten: 4 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 70038

Wednesday, May 25, 2011 1:03:31 PM



Page 2

Item ID: D3372-1

Accept



Setup Start



Revision ID:

Item Name: Main Body

Stop



Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00				4	0		
140  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				4	0	11-7-18	
150  Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3  M 102301 Memo ***Mask all holes and interior of the big hole***	0.00  0.00				4	0	11-7-18	

START TIME: 2:45  
OVEN TEMPERATURE: 320°  
FINISH TIME: 3:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 70038**

Wednesday, May 25, 2011 1:03:31 PM



Page 3

Item ID: D3372-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Main Body

Start Date: 5/25/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/10/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							4 of 11 ulozl12
170  Packaging Packaging	Identify as per dwg & Stock Location <u>GA</u>  Memo	0.00  0.00		8 11/10/12		(4)			
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							11/10/13 18 mf 11-10-12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, May 25, 2011 1:03:28 PM

Page 1

Work Order ID: 70038



Parent Item: D3372-1



Parent Item Name: Main Body

Start Date: 5/25/2011

Required Date: 6/10/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A 05.01.18 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B30000X01.5 00		Purchased	No			100	f	22.5880	0.375	1.578947			



6061-T6 Bar 3.00 x 1.50

Location

Loc Qty

Loc Code

MAT010

22.588

109058

1.667

→ 114468

10.5

117653

10.421

1.58      *only 11/07/07*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	70038
<b>Description: Main Body</b>		<b>Part Number:</b>	D3372-1
<b>Inspection Dwg: D3372      Rev: B</b>		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.377	+0.005/-0.000	Ø 0.382	✓		Vcln	6A-01
0.313	+/-0.010	0.312	✓		"	"
0.750	+/-0.010	0.748	✓		"	"
1.375	+/-0.010	1.376	✓		"	"
2.938	+/-0.010	2.932	✓		"	"
2.200	+/-0.010	2.193	✓		"	"
4.31	+/-0.030	4.311	✓		"	"
1.50	+/-0.030	1.500	✓		"	"
Ø1.300	+0.005/-0.000	Ø 1.300	✓		"	"
1.400	+/-0.010	1.400	✓		"	"
0.635	+0.010/-0.000	0.636	✓		"	"
0.750	+/-0.010	0.749	✓		"	"
0.200	+/-0.010	0.195	✓		"	"
Ø0.750	+0.010/-0.000	Ø 0.750	✓		"	"

<b>Measured by:</b>	A.A.
<b>Date:</b>	11/07/14

<b>Audited by:</b>	aw
<b>Date:</b>	11/07/15

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	08.09.09	Dimensions revised	KJ/DD	



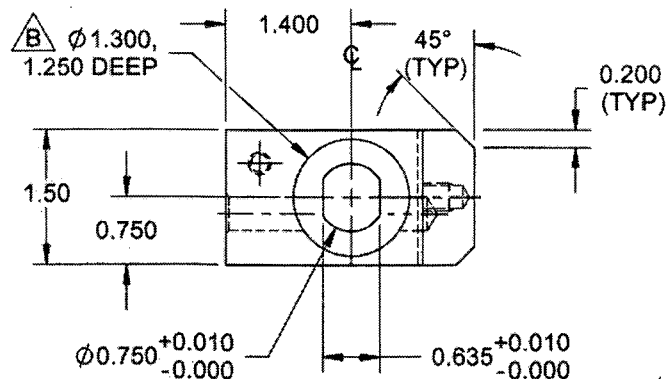
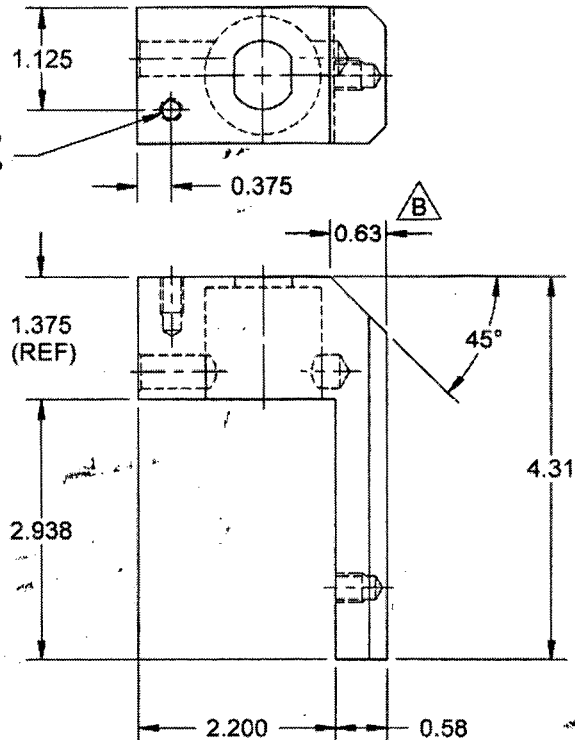
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3372</b>	REV. B SHEET 4 OF 8
DATE <b>05.02.23</b>		TITLE <b>COLLECTIVE LOCK</b>	SCALE <b>1:2</b>

RELEASED

2 DRILL Ø0.201 x 0.600 DEEP  
TAP 1/4-20 UNC x 0.400 DEEP

2 DRILL  $\varnothing 0.377$ ,  
2.363 DEEP.  
CHAMFER  $0.031 \times 45^\circ$

2 DRILL "I" DRILL  
x 0.525 DEEP  
THREAD 5/16-24 UNF  
x 0.300 DEEP



## D3372-1 MAIN BODY

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) W10. 7  
(REF. DART SPEC. M6061T6B)  
2) COVER INSIDE HOLES PRIOR PAINTING  
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES  
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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